

Work Order ID 81051-1

\*81051\*

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March-07-12 2:23:01 PM

Item ID: D2888

Revision ID:

Item Name: Lug

Start Date: 07/03/2012 Start Qty: 12.00

Required Date: 21/03/2012 Req'd Qty: 12.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

\*12\*

\*12\*

Run Start \*NR1\*

Stop \*NR2\*

Approvals: Process Plan: MLCJ

Date: 12/03/07 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2888

Rev A2

100

0.00

\*100\*

Bandsaw

Jeaspa Bandsaw

Memo

Cut Blanks at 4.200" long  
\*\*\*Grain along 4.200"\*\*\*\*

0.00

110

0.00

\*110\*

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio D2888

Folio Rev: AA

Dwg Rev: A2

0.00

2-Deburr

20 12-4-13 16

25 12-04-16 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81051

**\*81051\***

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Item ID:	D2888	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Lug					
Start Date:	07/03/2012	Start Qty:	12.00	<b>*12*</b>	Cust Item ID:	
Required Date:	21/03/2012	Req'd Qty:	12.00	<b>*12*</b>	Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

RT 12-04-16 (x2)

SL 12-04-16

26 12-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



March-07-12 2:23:01 PM

Page 3

0.00

2x

Q

camp  
m-h  
12/04/16

24

DL 12-4-16.

12/4/16

~~12/14/19~~

MF  
12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 81051****\*81051\***

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March-07-12 2:23:01 PM

Item ID: D2888

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Lug

Start Date: 07/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


**\*180\***

QC

Memo

0.00

Quality Control

12/4/12 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

March-07-12 2:23:07 PM

Page 1

Work Order ID: 81051

\*81051\*

Parent Item: D2888

\*D2888\*

Parent Item Name: Lug

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	8.0000	0.39	4.68			

\*M6061T6B2 500X03 500\*

6061-T6 Bar 2.50 x 3.50

\*\*

24 12.4.13

Location

Loc Qty

Loc Code

MAT008

8

120708 ✓

8

not in system

118071 ✓

x 12

4.25'

x 4 blanks

1.416'

5.666'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	81051
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	.3865	✓		vern	RT-4
Ø0.88	+/-0.030	.874	✓		"	"
0.063 x 45°	+/-0.010	.065	✓		"	"
4.06	+/-0.030	4.064	✓		"	"
Ø0.760	+0.005/-0.000	.760	✓		"	"
3.48	+/-0.030	3.484	✓		"	"
2.500	+/-0.010	2.498	✓		"	"
2.75	+/-0.030	2.75	✓		"	"
0.438	+/-0.010	.434	✓		"	"
0.080 x 45°	+/-0.010	.090	✓		"	"
1.85	+/-0.030	1.851	✓		"	"
1.000	+/-0.010	1.001	✓		"	"
0.425	+/-0.010	.425	✓		"	"
0.030 x 45°	+/-0.010	.032	✓		"	"
1.875	+/-0.010	1.881	✓		"	"
0.375	+/-0.010	.374	✓		"	"
R0.25	+/-0.030	.250	✓		rad gauge	
1.29	+/-0.030	1.288	✓		vern	RT-4
0.414	+/-0.010	.419	✓		"	"
3.41	+/-0.030	3.419	✓		height gauge	31006

Measured by: <u>JE</u>	Audited by: <u>SL</u>	Prototype Approval:	N/A
Date: <u>12-04-16</u>	Date: <u>12-04-16</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD <u>JD</u>	<u>JD</u>



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

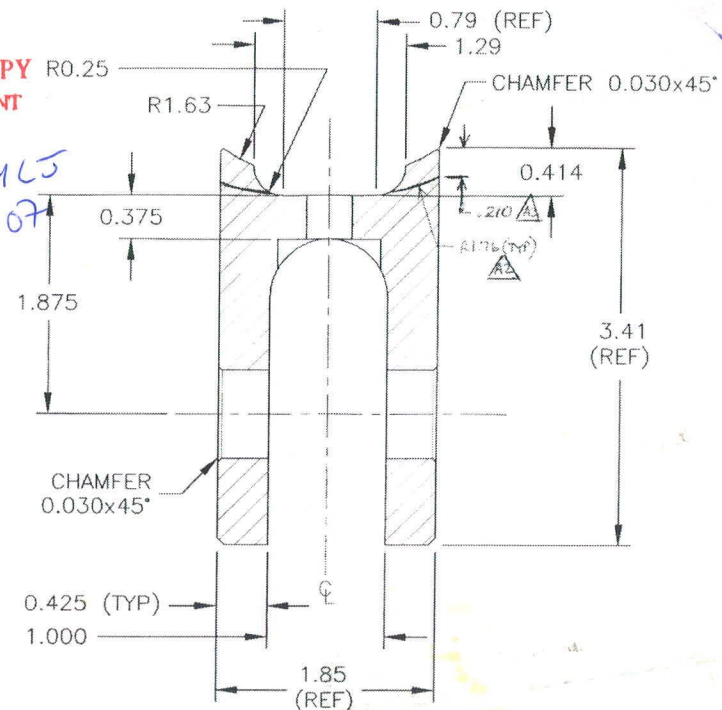
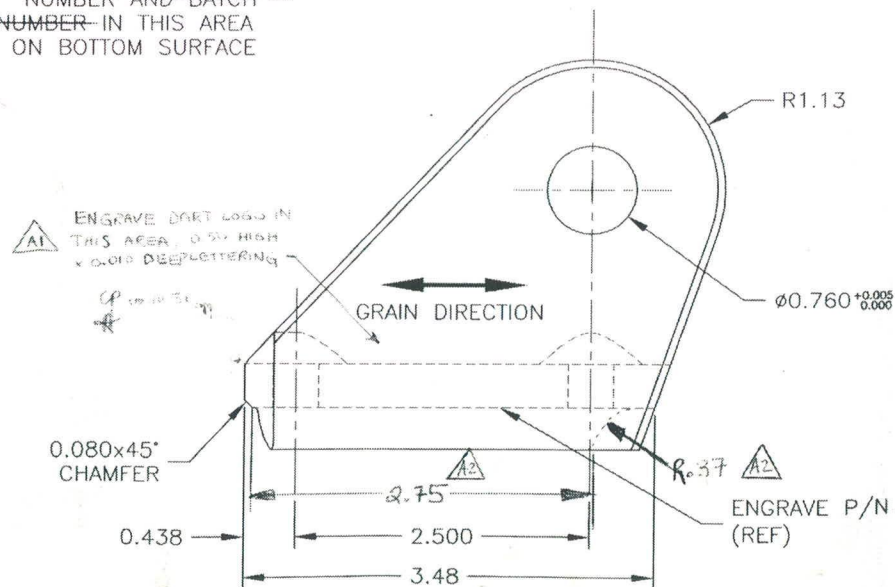
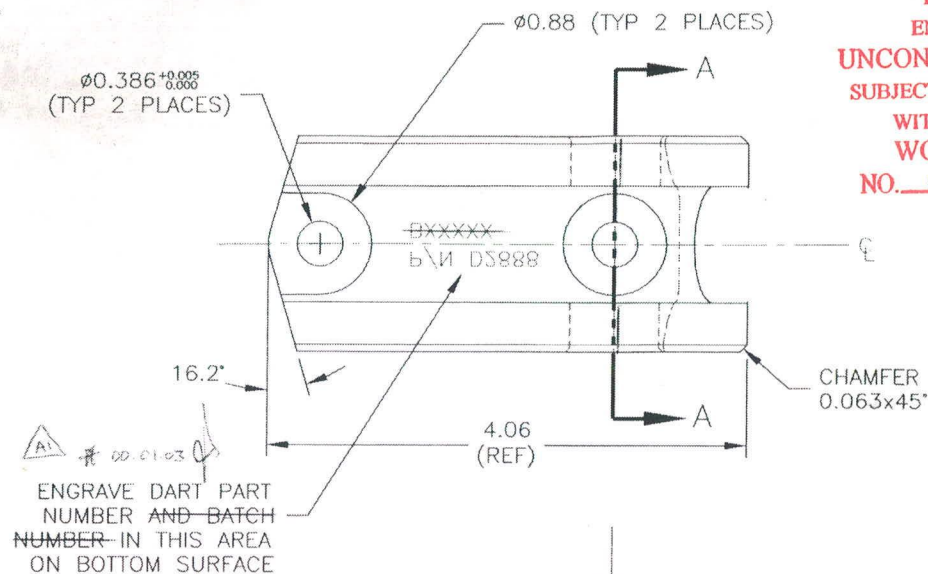
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81051 MLS  
12/03/07



SECTION A-A  
SCALE 1:1

RELEASED  
97.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BREAK UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 734	99.06.21	NEW ISSUE	DESIGN	DRAWN BY	APPROVED	DART	DART AEROSPACE LTD WILKESBURY, ONTARIO, CANADA	REV. A
A1	07.10.31	Update Engineering	99.06.21		CHECKED			D2888		SHEET 1 OF 1
					DATE			LUG		SCALE 1:1

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2112  
384  
2.596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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